














Date: Tuesday, 6/13/2006 3:29:02 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPRING CLIP ASSEMBLY
Job Number : 27523	
Estimate Number : 10645	
P.O. Number : N/A	Part Number : D2429041
This Issue : 6/13/2006 S.O. No. : N/A	Drawing Number : D2429 REV C1
Prsht Rev. : NC	Project Number : N/A
First Issue : 6/12/2006 Type : PURCHASED PARTS	Drawing Revision : C1
Previous Run : 25484	Material : N/A
Written By : <u>SPR / COMMENT BELOW</u>	Due Date : 6/30/2006
Checked & Approved By : _____	Qty: <u>3</u> Um: Each
Comment : Est. D 02.03.06 Added note at step 7 NG	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation:
Description :	
1.0 WATER JET	FLOW WATER JET
	
Comment: FLOW WATER JET <i>Dwg: C1</i> <i>Prog: C2</i> <i>SAP 06:06:20</i> (3) (PU)	
2.0 M304S20GA	304/316 .040 Sheet
	
Comment: Qty.: 0.0500 sf(s)/Unit Total : 0.2500 sf(s) 304/316 .040 Sheet <i>SAP 06:06:20</i> (3)	
3.0 PACKAGING 1	PACKAGING RESOURCE #1
	
Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached <i>N/A</i>	
4.0 QC5	INSPECT WORK TO CURRENT STEP
	
Comment: INSPECT WORK TO CURRENT STEP	
5.0 SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr <i>SAO 06:07:04</i> (3) 2-Bend D2429-1 as per Dwg D2429 <i>SB 06/07/05</i> (3)	
6.0 MS20470AD45	Rivet, Universal Head
	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Rivet, Universal Head Pick: Qty Part number Description Batch (3)	

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPRING CLIP ASSEMBLY

Job Number: 27523

Part Number: D2429041

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 MS20470AD4-5 Rivet *MIX 461*

7.0 AN960JD6L Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

Qty	Part number	Description	Batch
2	AN960JD6L	Washer	<i>M5519</i>

NOTE: 2 D2429-1 required for 1 assy.

SAD 06/07/20

(6)

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble D2429-041 as per Dwg D2429

SAD 06/07/20

(3)

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.07.20 (3)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST41*

AB 06/07/21

(3)

11.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/07/24 (3)

Job Completion



HA 06.07.24

Date: Monday, 6/12/2006 3:43:20 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPRING CLIP ASSEMBLY
Job Number :	27523		
Estimate Number :	10645		
P.O. Number :		Part Number :	D2429041
This Issue :	6/12/2006	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2429 REV C1
First Issue :	//	Project Number :	N/A
Previous Run :	25484	Drawing Revision :	C1
	Type :	Material :	
	PURCHASED PARTS	Due Date :	6/30/2006
Written By :		Qty:	5
Checked & Approved By :		Um:	Each
Comment :	Est. D 02.03.06 Added note at step 7 NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Note: Qty 2 pieces required per assembly

Issue P/O

Make D2429-1 Flat Pattern as per Dwg D2429

Material release note required

Material: (m30450040)
 Batch M101264

2.0	D24291F	Spring Clip Ass'y
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Comment: Qty: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Spring Clip Ass'y

SAD 06:06:20

(6)

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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QC2



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

SAD 06:06:20

(6)

4.0	QC 8.	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

06.06.22 (6)


5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Bend D2429-1 as per Dwg D2429

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-07-20	1	Add Note for 2 pieces req'd for 1 ASS'y. 26 parts = 12 x D2429-1 Perm. change.						

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/12/2006 3:43:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPRING CLIP ASSEMBLY

Job Number: 27523

Part Number: D2429041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Rivet, Universal Head

Pick:

Qty	Part number	Description	Batch
1	MS20470AD4-5	Rivet	

7.0

AN960JD6L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

Qty	Part number	Description	Batch
2	AN960JD6L	Washer	

NOTE: 2 D2429-1 required for 1 assy.

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble D2429-041 as per Dwg D2429

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

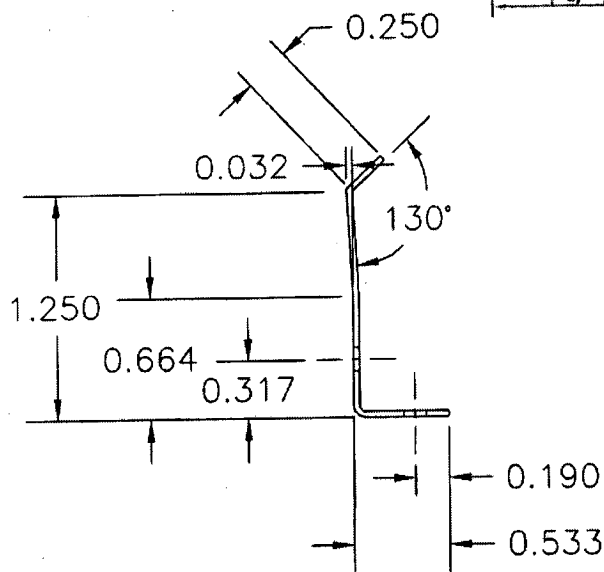
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

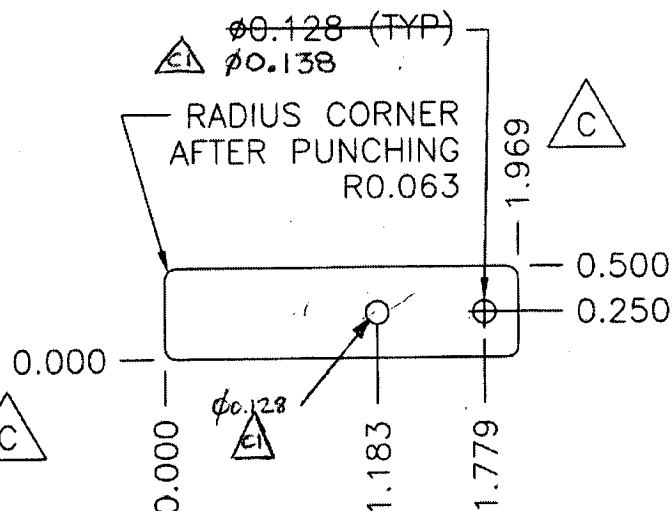


DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2429	REV. C SHEET 1 OF 1
DATE 00.06.26		TITLE SPRING CLIP	SCALE 1:1
A	95.07.21	NEW ISSUE	
B	97.10.09	ADDED ASSEMBLY	
C	00.06.26	1.969 WAS 2.100; 0190 WAS 0.321	
C1	UP # 01.03.27	Ø 0.138 WAS Ø 0.128	

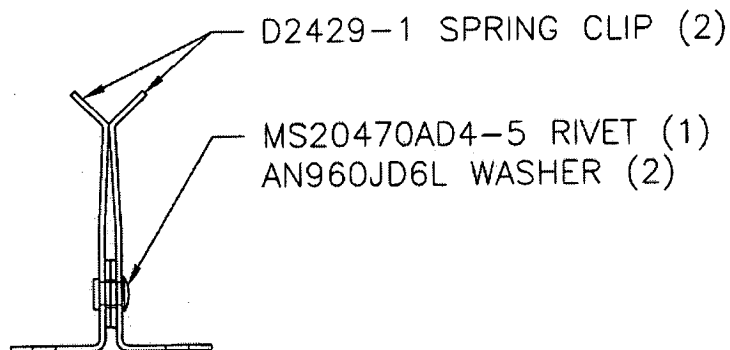
RELEASED
00.06.27 #



D2429-1 SPRING CLIP



D2429-1 FLAT PATTERN



D2429-041 SPRING CLIP ASSEMBLY

MATERIAL: AISI 304/316 SS 0.040 THICK 0.50 WIDE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSION ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NOTED 27523

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